












Date: Tuesday, 27/01/2009 11:13:34 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DRIVE SHAFT TUNNEL
Job Number	: 45286		
Estimate Number	: 13044		
P.O. Number	:	Part Number	: D3648041
This Issue	: 27/01/2009 S.O. No. :	Drawing Number	: D3648 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 41982	Material	:
Written By	:	Due Date	: 05/02/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 09.01.27</u>		
Comment	: Est Rev:A New Issue 07-10-03 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD verified by: EC Est Rev:C ECN1162 08-04-02 DD verified by: EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D3649041	Tunnel Bottom Panel Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) TUNNEL ASSEMBLY, BOTTOM PANEL batch: B 45306 B 42 038 FF 09/02/03 ①			
3.0	D3650041	Tunnel Top Panel Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WELDMENT ASSEMBLY, TOP PANEL batch: B 45306 FF 09/02/03 ①			
4.0	D3651041	Aft Base Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) AFT BASE ASSEMBLY batch: B 42040 FF 09/02/03 ①			
5.0	AN3C3A	Bolt	
			
Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt batch: 110322 FF 09/02/03 ①			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DRIVE SHAFT TUNNEL

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 40.0000 EACH(s)/Unit Total: 40.0000 EACH(s)

WASHER

batch: M109165

FF 09/02/03

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3648

FF 09/02/04

2- Seal mating surface and all gaps as per dwg D3648 with

Proseal 700 fire wall sealant

batch: M110624

M-h 04/02/04

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/02/04 (40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

PPP 45166

9/2/04

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/04

Job Completion



MF 09-02-04

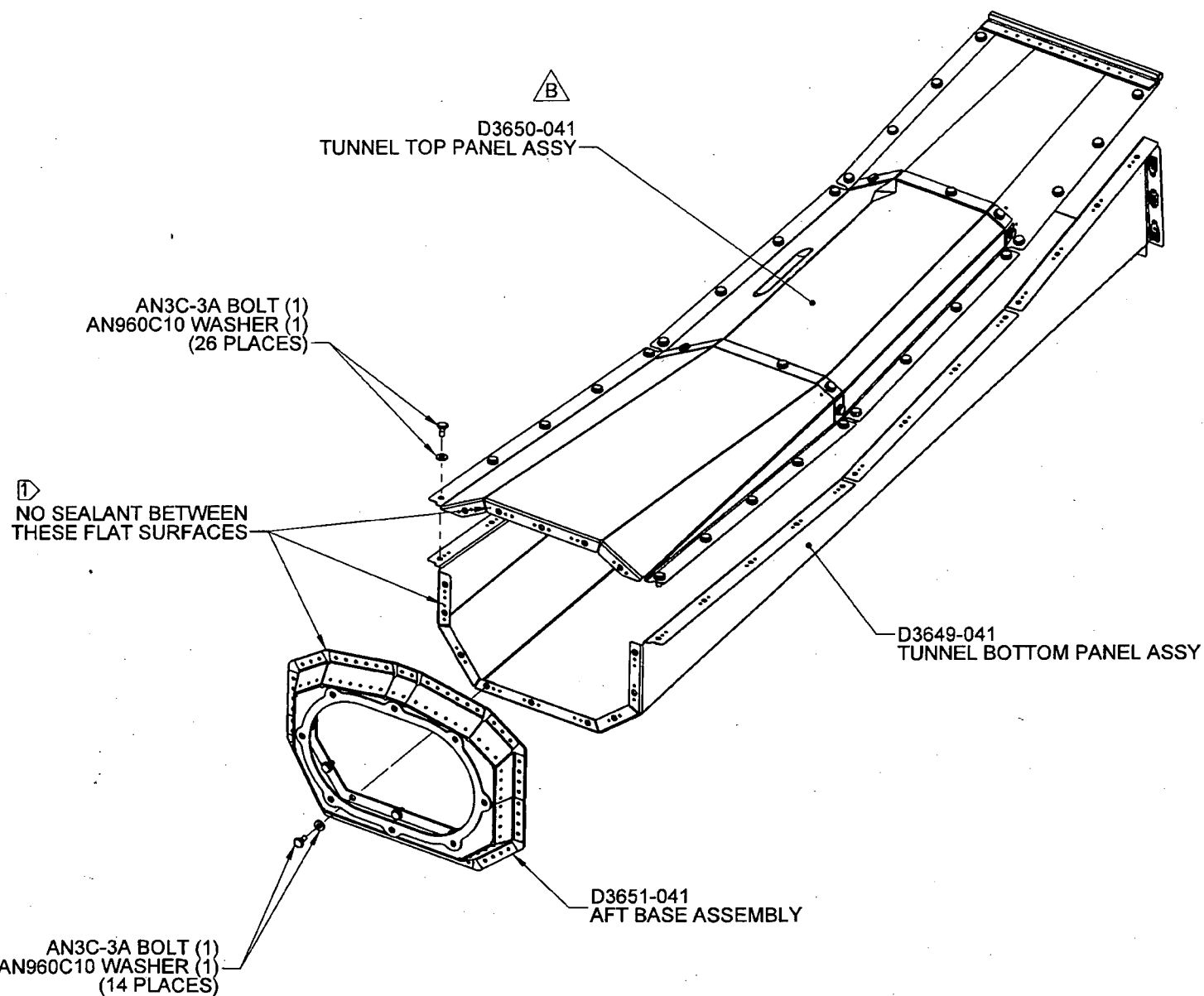
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

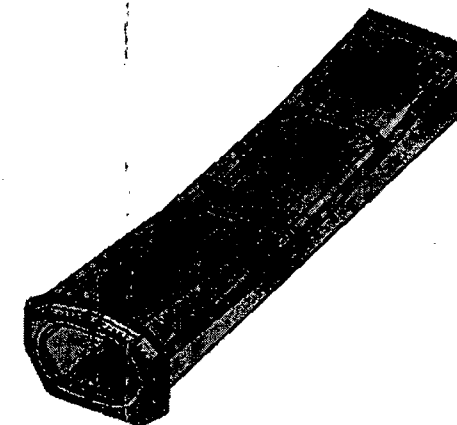
NOTE: Date & initial all entries



D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
08.03.27/11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 452860

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3648	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	DRIVE SHAFT TUNNEL ASSY	1:6
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

